

Date: Wednesday, 6/28/2006 10:14:32 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	27714		
<b>Estimate Number</b> :	12428		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D35061
<b>This Issue</b> :	6/28/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3506 PRELIMINARY
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	N/A	<b>Drawing Revision</b> :	PREL
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	7/5/2006
<b>Written By</b> :	<b>Qty:</b>		8
<b>Checked &amp; Approved By</b> :	<b>Um:</b>		Each
<b>Comment</b> :	Est Rev:A New Issue 06-05-31 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S100	6061-T6 .100 Sheet
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**Comment:** Qty.: 0.0082 sf(s)/Unit Total : 0.0655 sf(s)  
 6061-T6 .100 Sheet  
 (M6061T6S0100)  
 Batch: M7669

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3506  
 Dwg Rev: Pre1  
 Prog Rev: Pre1

2-Deburr if necessary

SAD 06-06-29

8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06-06-29

8

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA640 and Dwg D3506

SAD 06-06-29

8

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06-06-29

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 10:14:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27714

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/01/22 xg

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3506(On Flat side)

SB 06/06/29 8

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 06-06-30 8

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-06-30

(8)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J 06-07-03 8

(8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 44B

H.M 06-07-04

(8)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date, 06-07-05  
Do Not file this w/p, Please hand  
in to Peter Hum, For conformity Report.  
(We will file it after) J.M.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

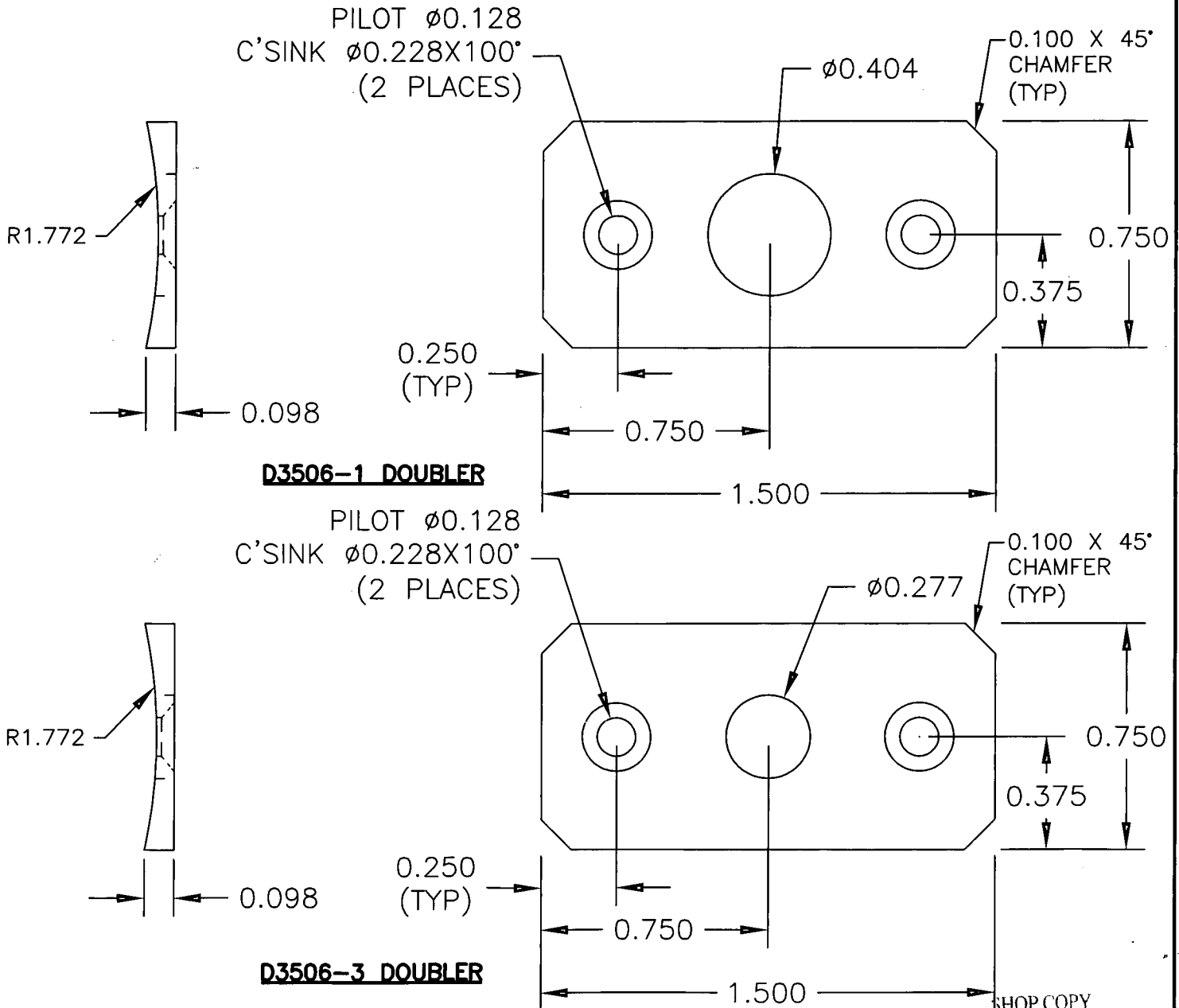
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

PRELIMINARY ISSUE

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21	TITLE DOUBLER		SCALE 2:1
A	06.04.21	NEW ISSUE	



**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27714

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DART AEROSPACE LTD		Work Order: 27714
Description:		Part Number: D3506-1
Inspection Dwg: , Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

[illegible]

Measured by:	SAD	Audited by:	Er	Prototype Approval:	PH
Date:	06:06:29	Date:	06/06/29	Date:	06/06/29

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TO



Workproffzeugni  
Test Certificate  
Certificat de Controle  
EN 10204-2.3

Zeugnis-Nr.:  
 Certificate Nr.: 01/01  
 N° de certificat:  
 Datum:  
 Date: 20.03.1998  
 Dato:

A12672

Receiving No./Order No./Command No. 4139920

CONTRACT ER-2108-PLOT 27 OF

87346470810/1

1. Die Faktoren  $a, b, c, d, e, f, g, h, i, j, k, l, m, n, o, p, q, r, s, t, u, v, w, x, y, z$ :

Distance No. from Delivery Note No. of Aids & supplies. N° 22:

~~Erzeugung/Produktion~~

**BLECHE**

Oberfl. 63

Werkstoff und Zustand/Alloy and Temperature of test

**AA 8061**

**78**

Adressierung/Direktion (Werkzeug Nr. 10) Nr. 10

.100" x .48" x 144"

Underbetingning or Term of delivery / Stipulations de la commande:

1725/1 + 1748/1

1725/1 + 1748/1

CHEMISCHE ZUSAMMENSETZUNG / CHEMICAL COMPOSITION / COMPOSITION CHIMIQUE					
Si	P	O <sub>2</sub>	Mg	S	A

ANALYSIS REPORT / ANALYSE CHIMIQUE									
Specimen No. Echantillon N°	Si	P	S	Mn	Fe	C	Cr	Ni	
Charge No. Charge N°	Ermittelte Werte/Values obtained/Values obtenues (K)								
638404	0.68	0.37	0.23	0.02	0.84	0.17	0.01	0.03	

[illegible][illegible]

Probe Nr./Tut. No./  
Epreuves N°

Erreichte Werte/Values obtained/Values obtained	
1	1
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100	100

Charges: Nr.

[illegible]

according to AA, QQ-A250/11, ASTM B-209M-95 AMS, 4027H, MIL-H6088.

Es wird bestätigt, dass die Lieferung gemäß wurde und den  
Veranstaltungen bei der Bestellabnahme entspricht.  
We hereby certify, that the material described above has been  
received and complies with terms of the order contract.  
Nous certifions que le matériel était conforme à ses conditions  
aux stipulations de l'acceptation de la commande.

**Alumilux Slagen GmbH**  
Qualitätsprüfung Halbzeug Werk

**Jäger**

This is a copy of the original mill certificate.

Date 11/05/99 Prepared by SC  
 Rpt. 2 of 2

16000 Das  
 ...  
 Zugfedergelack  
 Tausche strengste  
 Befolgung & la